

# Work Order ID 74290

Tuesday, September 27, 2011 1:58:56 PM



Page 1

Item ID: D4306-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, RH

Start Date: 9/27/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: 11-09-27 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4306

C

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00



Large Fab

Large Fab

Memo

0.00

1- Cut tube 52"

2- Bend tube with manuel pipe bender as per DT9567

\*\*\* Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*

3- Trim access tube material to finish size and cut notch as per dwg D4306-4

4- Drill and chamfer holes as per dwg D4306-4 using DT9710

5- weld bushing as per dwg D4306

6- grind welds flush

*CP 11-09-29* *X2*

*CP 11-09-29*

*SPD 11-09-27*

*CP*

*CP 11-09-29*

110

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

0.00

*5-11-09-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 74290**

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Page 2

Item ID: D4306-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, RH

Start Date: 9/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

5/4/12



130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

PL 11-09-29

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/3

ME  
11-09-29

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 27, 2011 1:58:52 PM

Page 1

Work Order ID: 74290

Parent Item: D4306-044

Parent Item Name: Rib Assembly, RH

Start Date: 9/27/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC  
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

165.0000

4

4



Bushing

Location

Loc Qty

Loc Code

WA

163

72316

163

WA005

2

66489

2

M304TS0.750W.049

Purchased

No

100

f

341.4518

4.166

4.385263



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

267.0081839

11775

98.2133

118472

62.8252839

118880

105.9696

MAT034

1.8507

117337

1.8507

WA

72.59294

118184

72.59294



11-09-29

8



SAD 11-09-27

8.7704

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

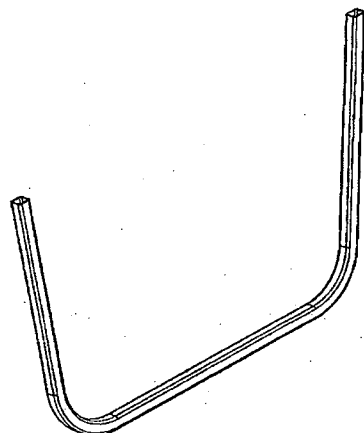
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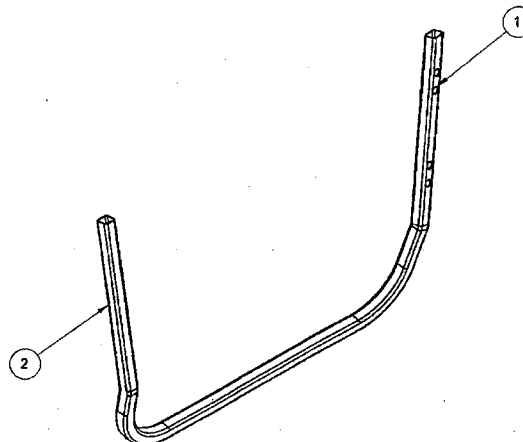
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**NOTE:** Date & initial all entries

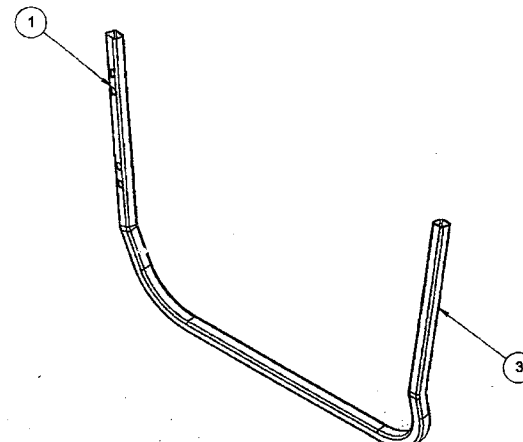
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	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



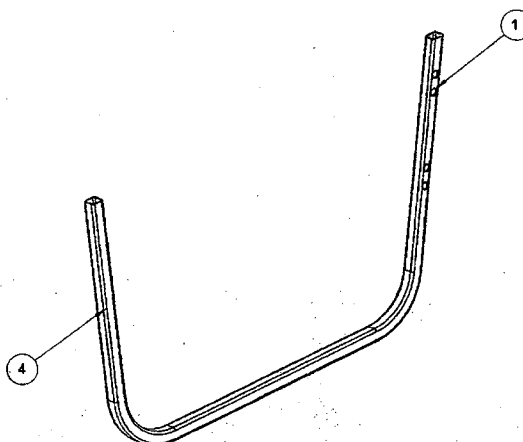
**D4306-1 RIB**



**D4306-043 RIB ASSY, LH**



**D4306-044 RIB ASSY, RH**



**D4306-045 RIB ASSY**

# 74290  
**RELEASED**  
2011-03-10

REV.	DESCRIPTION	BY	DATE
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-A8); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.85" (C7-4, C8-4, C1-8, C2-8); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-8); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-6)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4306</b> TITLE <b>RIB</b> SCALE <b>NTS</b> SHEET 1 OF 8 REV. C COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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DATE	11.02.09		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

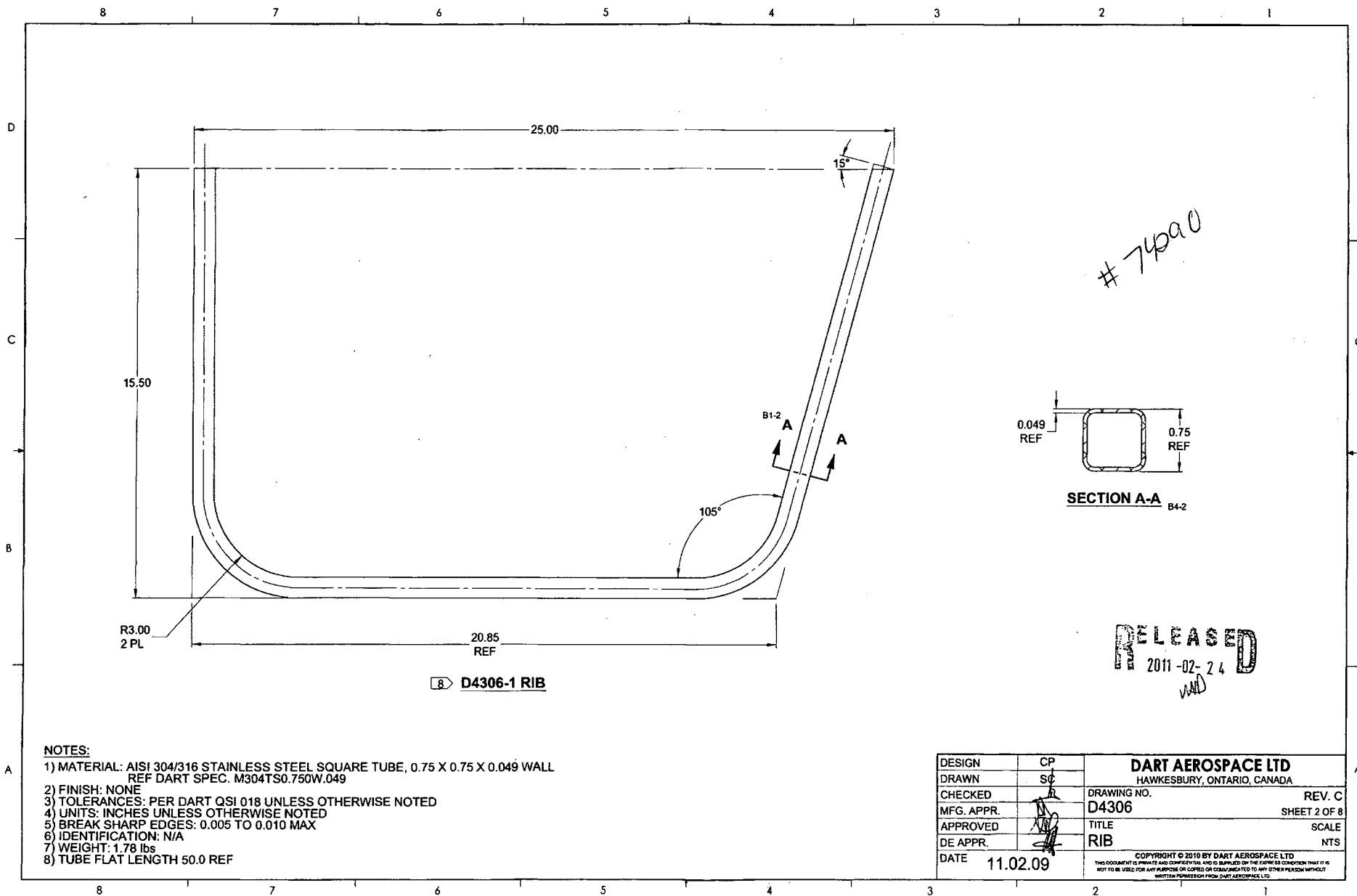
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





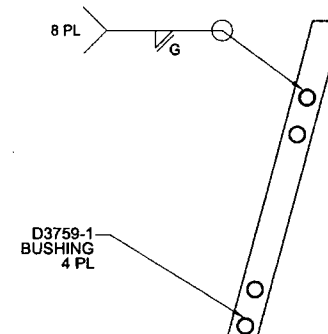
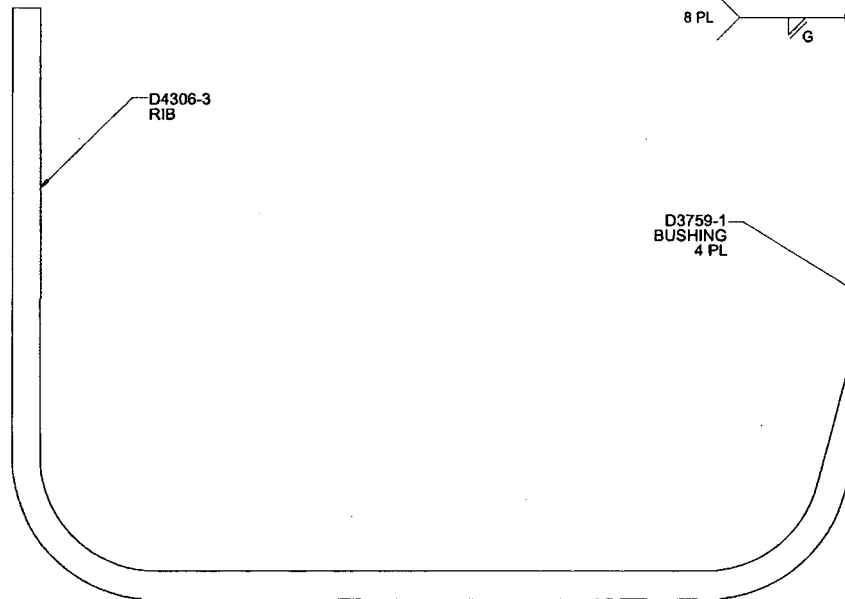
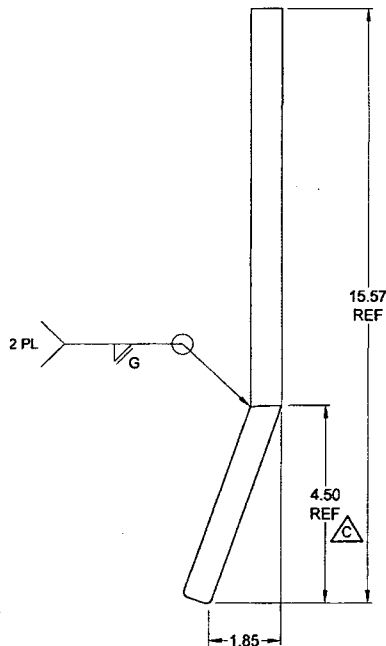
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D4306-043 RIB ASSY, LH**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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RELEASED  
2011-02-24  
ND

#74290

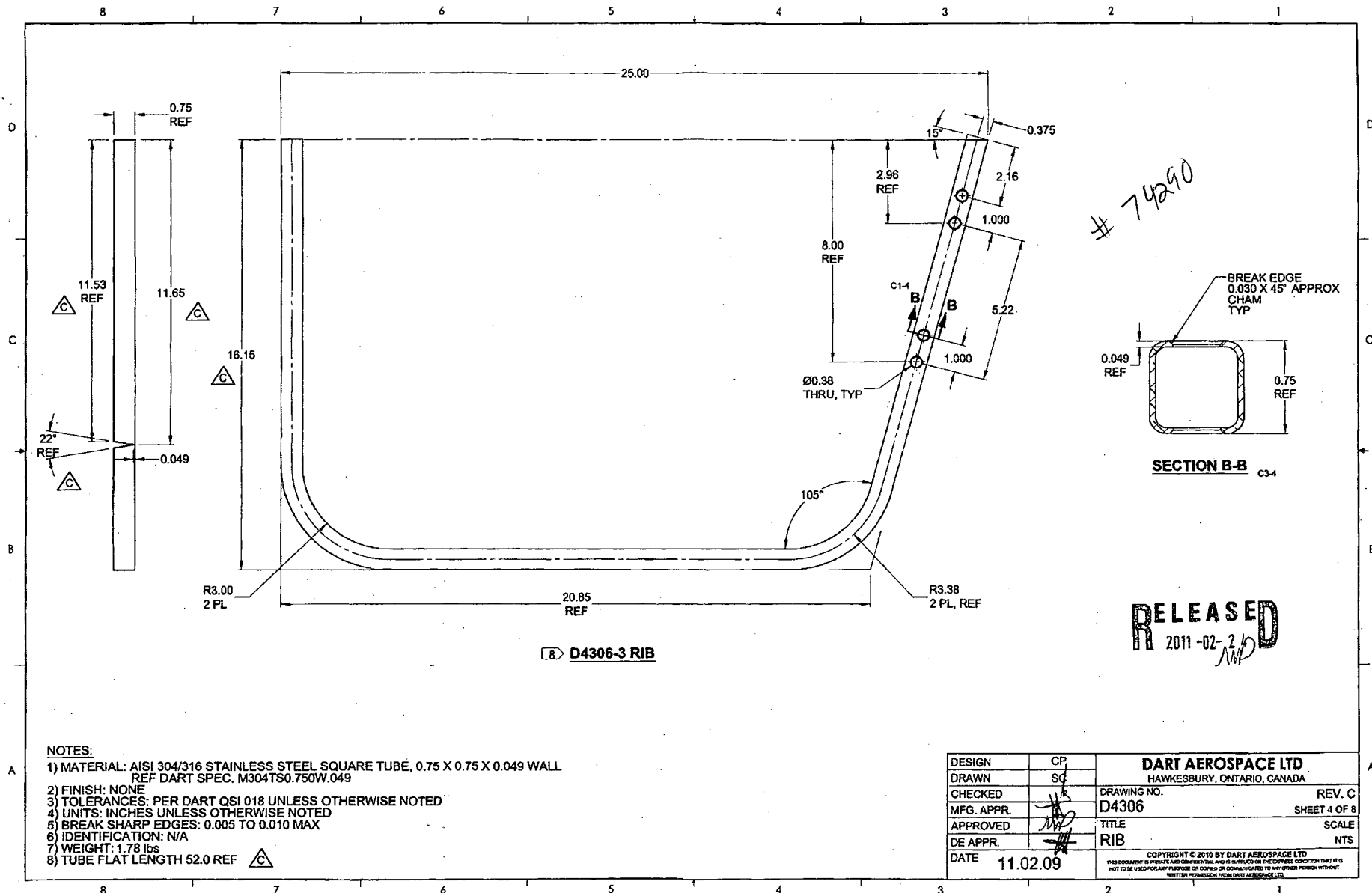
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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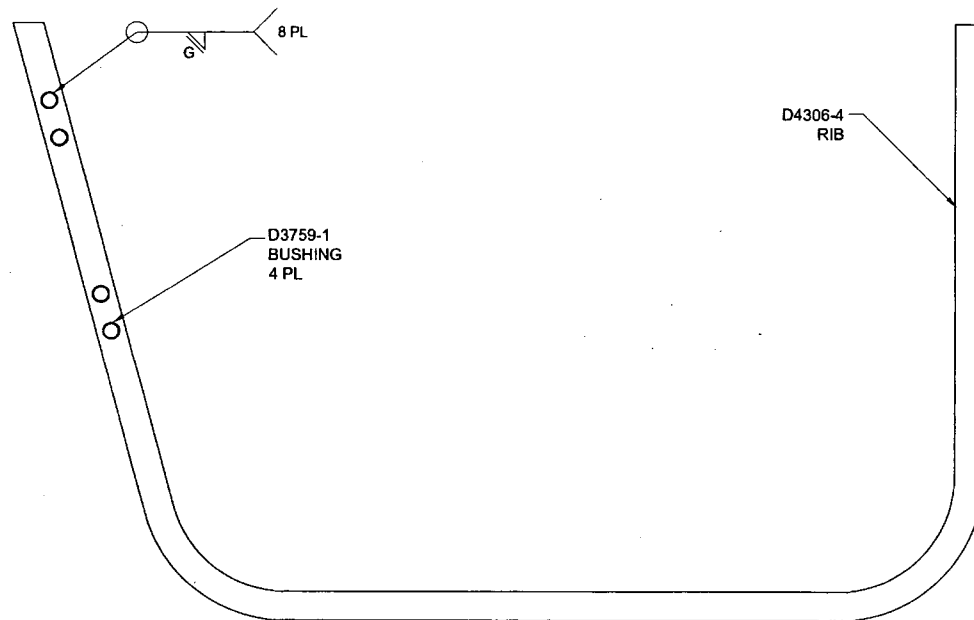
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4306-044 RIB ASSY, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	IS	<b>D4306</b>	SHEET 5 OF 8
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DE APPR.	IS	<b>RIB</b>	NTS
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2011-02-24

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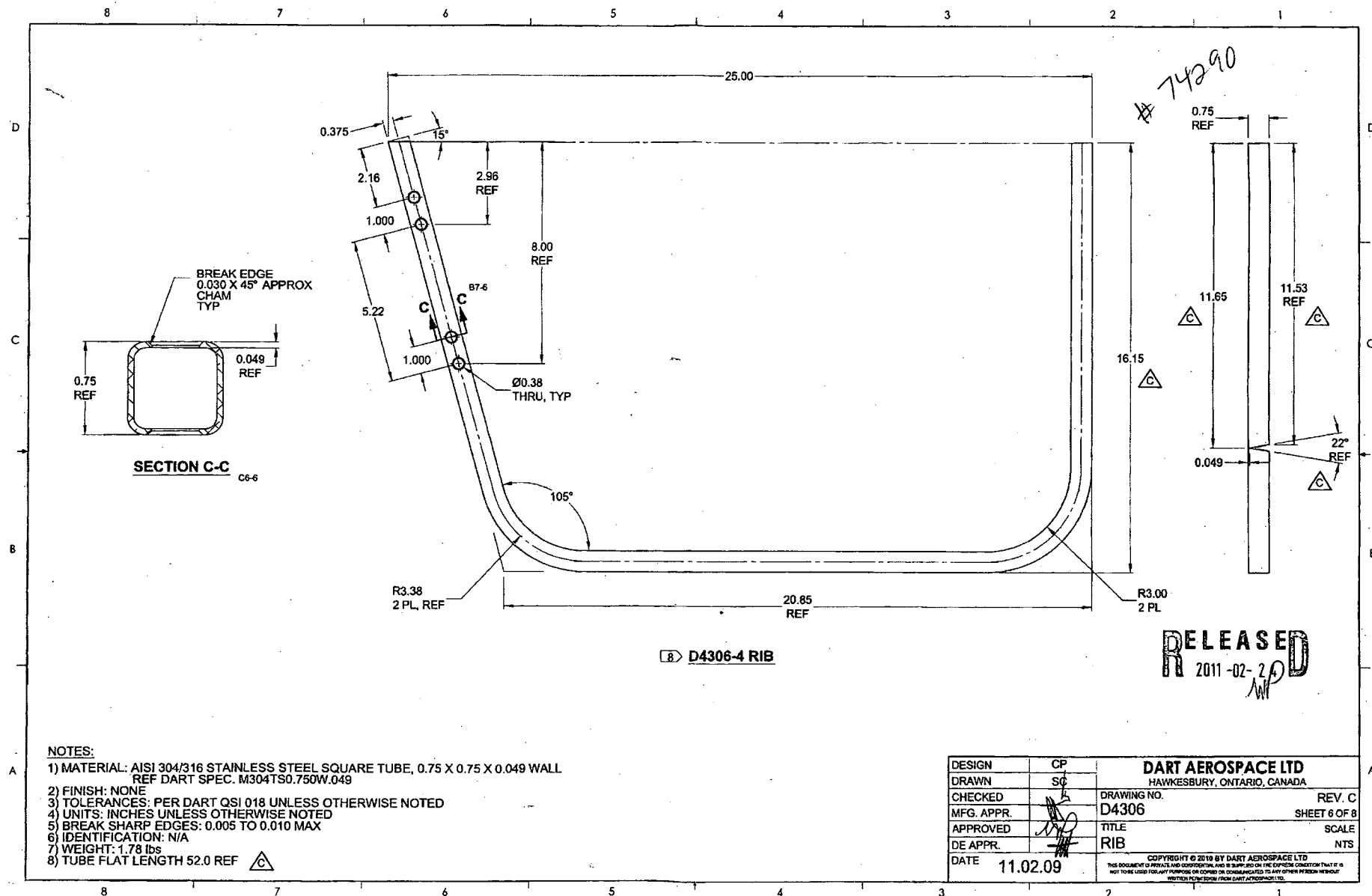
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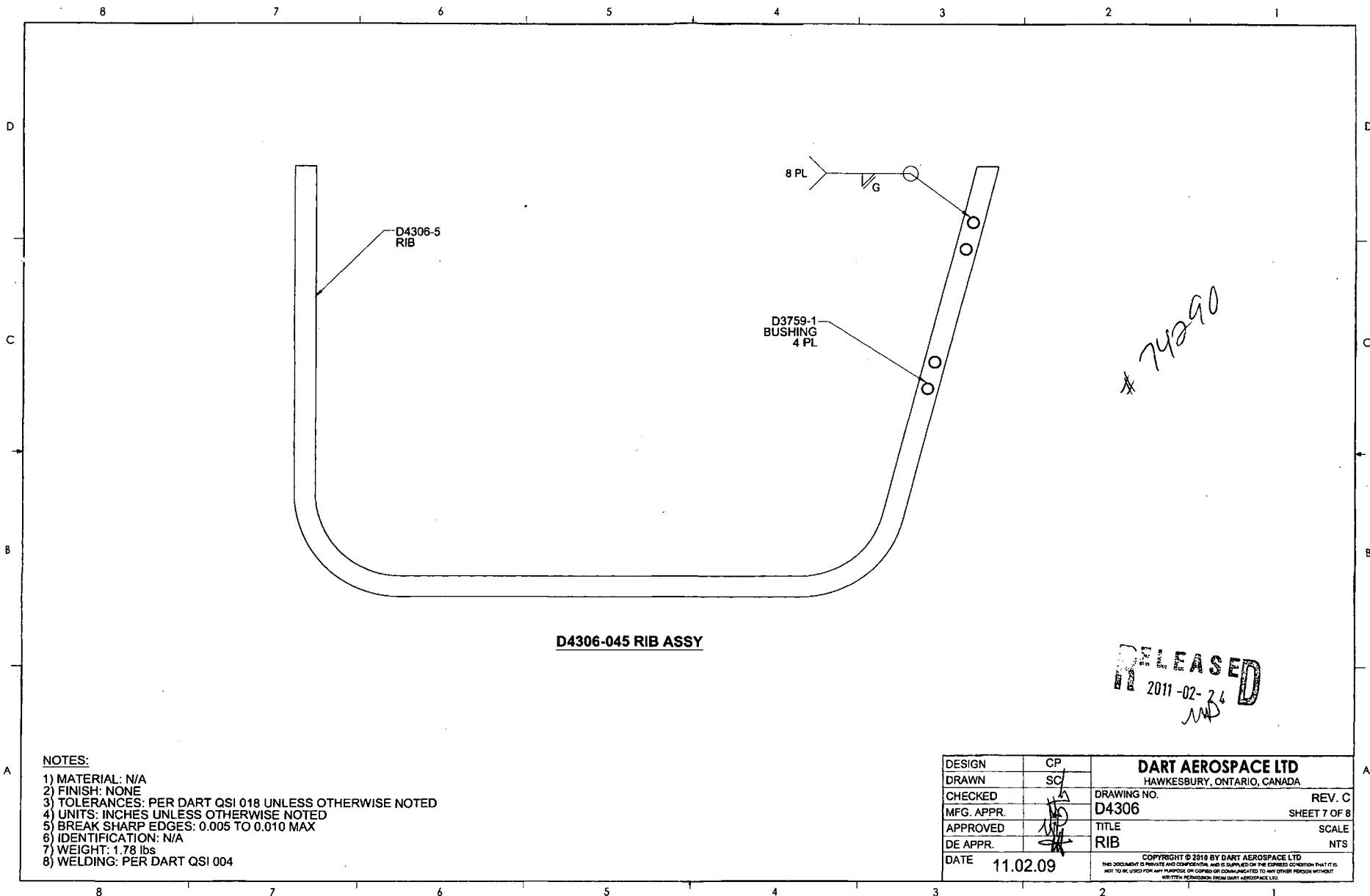
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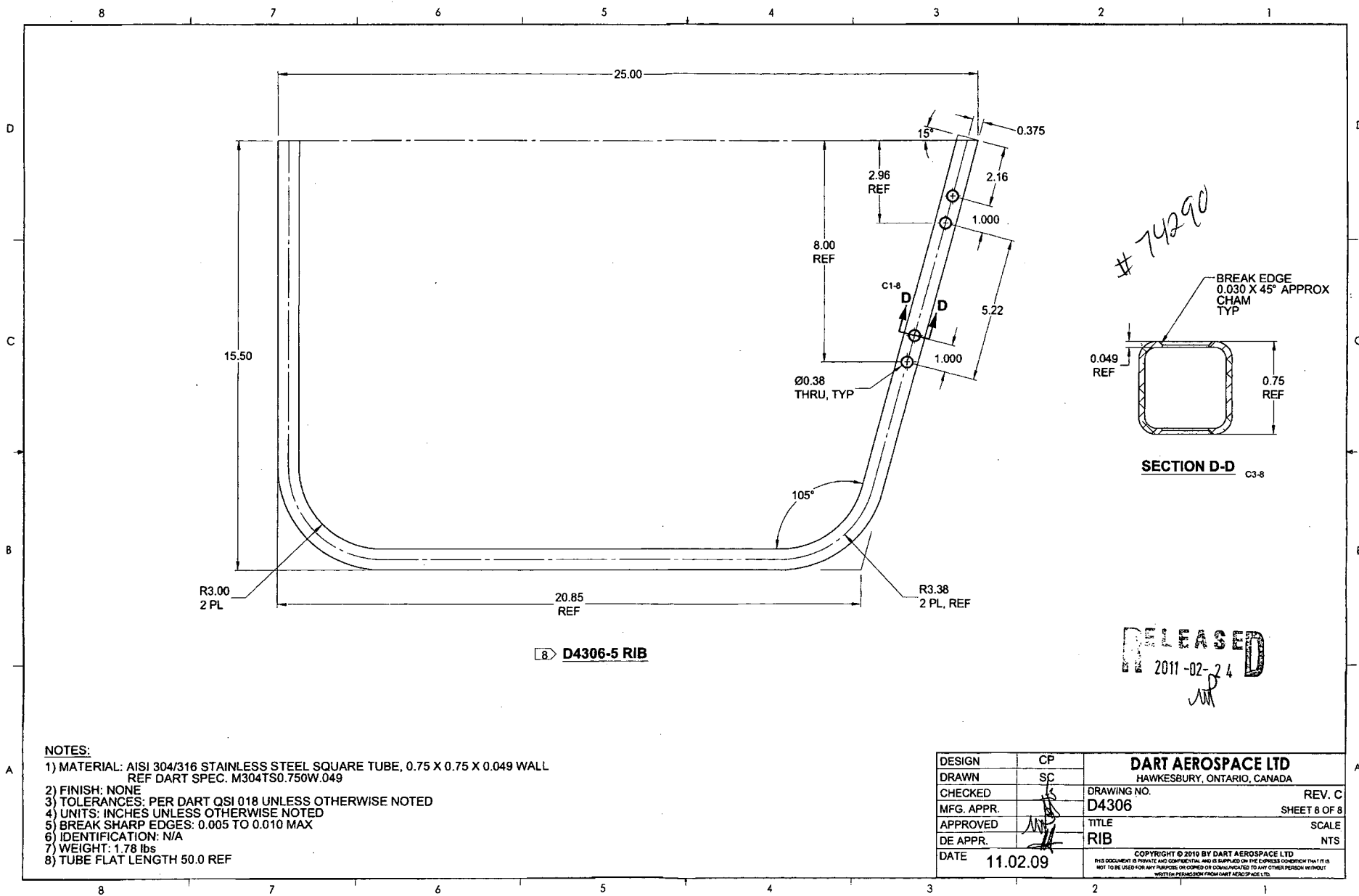
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**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
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